



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3414-041
Job Sheet 181535



Part No: D3414-041

Job Qty: 8 ea

Part Name: Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/31/18

Job Tracking No:

Due Date: 8/22/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		8/22/18	0.00	0.00	Start Up Waterjet		SC 12/18/18
100	Waterjet	8 pcs		8/22/18	0.00	0.60	Waterjet1		SC 8/18/18
120	QC	8 pcs		8/22/18	0.00	0.00	QC8		RD 12/23/18
130	Brake NC	8 pcs		8/22/18	0.05	0.45	Brake NC 1		CB
140	Large Fab	8 pcs		8/22/18	0.00	2.45	Large Fab 1		DK 10/09/24
150	QC	8 pcs		8/22/18	0.00	0.00	QC9		CL
160	QC	8 pcs		8/22/18	0.00	0.00	QC5		FL
170	Powdercoat	8 pcs		8/22/18	0.00	0.17	Powdercoat2		BL 10/09/25
180	QC	8 pcs		8/22/18	0.00	0.00	QC3		38
190	Packaging	8 pcs		8/22/18	0.00	0.00	Packaging3-1		SEP 28 2018
200	QC21-SA	8 Ea		8/22/18	0.00	0.00	QC21		OCT 02 2018

Part Op 100 - 1-Cut as per Dwg D3414-1 Dwg Rev: _____ Prog Rev: _____ 2-Debur if necessary

Descriptions: 130 - 1-Debur 2-Form using DT8254 as per Dwg D3414

140 - 1- Weld using location jig DT9625 as per Dwg D3414 A/P S.S. welding rod Batch: M136585

170 - START TIME: 9:15 OVEN TEMPERATURE: 400 FINISH TIME: 9:45

M18398

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S12GA	304/316 0.100" Sheet	1.2400 sf (.155 ea)	90-Start up Operation	
D3414-3	Lug	8 Ea (1 ea)	140-Large Fab	503842

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S12GA	1	55	0
140-Large Fab	D3414-3	8	53	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lug Bracket	0.313inches + 0.006 - 0.001	0.319 0.312		
2	Lug Bracket	1.190inches ± 0.030	1.220 1.160		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order update only ☐

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4	Lug Bracket	3.380inches $\pm$ 0.030	3.410 3.350
5	Lug Bracket	5.350inches $\pm$ 0.010	5.360 5.340
6	Lug Bracket	6.230inches $\pm$ 0.030	6.260 6.200
7	Lug Bracket	2.500inches $\pm$ 0.010	2.510 2.490
8	Lug Bracket	0.370inches $\pm$ 0.030	0.400 0.340
9	Lug Bracket	0.100inches $\pm$ 0.010	0.110 0.090

Plex 7/31/18 1:28 PM Dart.lajeunesse.marie

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